

Date: Wednesday, 2/20/2008 4:27:25 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET
Job Number	: 37560			
Estimate Number	: 10854			
P.O. Number	:		Part Number	: D350721041
This Issue	: 2/20/2008	S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: / /	Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 37495		Material	:
Written By	:		Due Date	: 3/30/2008
Checked & Approved By	:		Qty:	1
Comment	:		Um:	Each
	:	Est Rev: B as per Rev B 05-11-21 JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-721-041CHG002

006136 08/03/03

2.0	37560A	BASKET LID ASSEMBLY	
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Comment: Sub-Component BASKET LID ASSEMBLY

D3325-041 B 37560A

CB08/04/30 @

3.0 37560B BASKET BASE ASSEMBLY

Comment: Sub-Component BASKET BASE ASSEMBLY

D3324-041 B 5756078

08/04/30 @

4.0	PACKAGING 1	PACKAGING RESOURCE #1	
			

Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2022101	Spacer		
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

[illegible]

2 D2022-101

Spacer 33785

8/4/79 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: HELI UTILITY BASKET

Job Number: 37560

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2332-041

prop arm

36849

SP

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch:

37544

SP

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2535

Spring

37071

SP

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2537

Bushing

37605

SP

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2931

Bumper

21139

SP

11.0

D3320041

Webbing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D3320-041

Webbing

32586

SP 8/4/29

SP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33511

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3351-1

Label 34755

SP

13.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt 106815

SP

14.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt 102140

SP

15.0

AN420A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-20A

Bolt 16895

SP

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt 104937

SP

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt 107242

8/4/29

SP

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Job Number: 37560

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer 107321

sq

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer 107008

sq

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer 107008

sq

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer 107091

sq

22.0

AN960JD9

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 AN960JD9

Washer 105356

sq

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer 107242

5/4/29

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 37560

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 MS20600AD4W3 Rivet 18071

SP

25.0

MS20600AD4W2

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS20600AD4W2 Rivet 19454 106513

SP

26.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3 Nut (or -3) 107643

SP

27.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4 Nut (or -4) 106051

SP

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5 Nut (or -5) 106785

8/4/29

SP

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 37560

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PTO

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D350-721 Attach Travelers:

Seal rivet Holes with Sika Flex before riveting

A/R 291 Sika Flex

Batch:

1105585

Exp Date:

10/2008

EB08/04/30 @

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

006430 @

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

D22301

Mounting Lug



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 D2230-1

Lug

36747

SP

33.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2230-3

Clamp

37744

SP

34.0

D2856400

Abrasion Strip



1x

Comment: Qty.: 2.5200 f(s)/Unit Total: 2.5200 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2856-4007.20"

Abrasion Strip

36161

8465

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-721-041 PAR #: N/A Fault Category: Prod / Pass ^{malfunction} NCR: Yes No DQA: PD Date: 08/04/30
 QA: N/C Closed: PD Date: 08/05/01

NCR: <u>37560</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/04/30</u>	<u>29</u>	<u>1 rivet was</u> <u>grind to deep</u> <u>human error, lack</u> <u>of attention on the</u> <u>employee's part.</u>	<u>[Signature]</u> <u>08/04/30</u>	<u>removed & replace</u> <u>1 new rivet</u>	<u>[Signature]</u> <u>08/04/30</u>	<u>[Signature]</u> <u>08/04/30</u>	<u>[Signature]</u> <u>08/04/30</u>	<u>[Signature]</u> <u>08/04/30</u>

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Drawing Name: HELI UTILITY BASKET

Job Number: 37560

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D33381

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3338-1

Lug

33248

SP

36.0

D3350041

Strut Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3350-041

Strut

34487 (X)

34921 X

SP

37.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4-12A

Bolt

105143

SP

38.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN4-13A

Bolt

107321

SP

39.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN4-14A

Bolt

105653

8/4/29

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 37560

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960JD416

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

28 AN960JD416

Washer

107321

50

41.0

MS21042L4

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

18 MS21042L4

Nut (or -4)

106051

8/4/09

50

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/30

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-721-041

Location:

PPP Rev:

08/4/30

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/30

Job Completion



08/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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